QC5- Inspect part completeness to step on W/O 0.00 112

QC

Memo

0.00

Quality Control

76-80.HI

2AQ

DQA:			Date:												DART
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QA Closed:	_		Date:	·							VVO	rk Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST I	DEP	ARTMENT	PROCESS		
	•					Rework]		Skid-tube	Crosstube			Water Jet		Engineering
Part N	۱٥.					Scrap Use-as-is			Machining noforming	Small Fab Finishing	\dashv		d. Eng. Coor.		Quality Other
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	\perp	Date	Verification		QC Inspector
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		Centre No	ot Concer	ntric		BOM/Route	L	Grain		<u> </u>		Over/Under			Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	<u></u>	Hardwa		1		Part Incorred	<u> </u>	\neg	Temperature/Cure
	<u></u>	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Ui	nqualified	-	Part Lost/Mi	ssing	-	Weld
	Crimp/Kink/Ripple/Wave Cuffs					Contamination		4	ions Incomplete/l	Unclear	\neg	Part Moved	L		Wrong Stock Pulled
	Crushing			Countersink		4 ~	ned/off center	Į		Positioned W					
	Heat Treat					Cut Too Short		Mislabe		L		Power Loss/S	Surge	\Box	Other
	Inspection Strip in Tube			Tube		Drawing		Misread			_				
	Marks/Chatter					Drill Holes		Off-set			_				
		Turning S	equence			Finish		Out of 0	Calibration		_	<u> </u>			
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence						

Work Ord June-03-14 7:1		0030		*120	^^30 *							Page
Item ID: Revision ID: Item Name:	D3391-025 Aft Tube Asse	embly		Accept	*N900	<u>040</u>	100)*	-	Start Stop	*N.	S1*
Start Date: Required Date Reference:	6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				•	^IV.	ハン ^
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:				Start Stop	*NI	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
*120 *120 HAAS 1 HAAS CNC vertical	ıl machine #1	Memo 1-Machine a 2-Deburr	MACHINING #1 s per Folio FA 599 Rev: <u>-</u>	0.00	I / N	14/10/12		1				
¹³⁰ *130*		QC2- Inspect parts off ma	achine FAI/FAIB	0.00	of /	/ /.		(

0.00

0.00

140

140

Quality Control

QC8- Inspect parts - second check

Memo

INSPECT INSIDE BORE

DQA:			_ Date:			<u>-</u>								`DART
						WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:			T				W	ork Order up	date only		· · · · · · · · · · · · · · · · · · ·
Work Orde	or.	,				DISPOSITION			AGAINST	ΓDE	PARTMENT,	PROCESS		.
WOIK OIG	٠١٠.					Rework			Skid-tube Crosstube	,	1	Water Jet	٦	Engineering
Part N	No.				·	Scrap			Machining Small Fab	\vdash	Pro	d. Eng. Coor.	┪	Quality
	•				 .	Use-as-is			noforming Finishing	3	Rec/Sto	re/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab Composite			Supplier		
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Root				·	Desc	ription of work order update	ı	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	\downarrow	QC Inspector
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		Cuffs	.	,		Contamination		1	ions Incomplete/Unclear	\vdash	Part Moved	- T	٦,	Wrong Stock Pulled
		Cuffs Crushing			F	Countersink		4	ned/off center		Positioned V	√rong		
		Heat Treat				Cut Too Short		Mislabe			Power Loss/	Surge		Other
		Inspection Strip in Tube				Drawing		Misread	d	_				
	Marks/Chatter					Drill Holes		Off-set						
1		Turning S	Sequence			Finish		Out of 0	Calibration					
	<u> </u>	Wave/Tw	vist in Tub	e		Fit/Function		Out of 9	Sequence					

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June-03-14 7:12		20030	,	*120	1030*							Page 3
Revision ID:	D3391-025 Aft Tube Ass			Accept	*N900	040	100) *	Setup	Start Stop	*N	S1* S2*
	6/03/14	Start Qty: 1.00	*1*		Cust Item 1	ID:						
Required Date:	6/03/14	Req'd Qty: 1.00	*1*		Customer:			٠				
Reference:									Run	Start	48 I	D1+
Approvals:	Process Pl	an:	Date:	Tooling:	D:	ate:				Stop	^IVI	H1^
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
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150		Skidtubes		0.00						/	14-16)-[4][//
Skidtubes Skidtubes		Memo 1-Drill (PIL	OT HOLE) aft cap holes	per Dwg D3391 using DT	8803		ě ě		·		l	
160				0.00								-15 DGC
160		BENDING MACHINE -	SKIDTUBES					/	01	S	ul in	LIS DGC
CNC Bend 1		Memo		0.00						<u> </u>		<u>/</u>
CNC Delta 100 Bend	ler * ***	Form as per	Dwg D3391 Using Bend	1 Prog 3391025								
170	i e	QC5- Inspect part compl	eteness to step on W/O	0.00			DAS			. •		•
170		Мето		0.00			03 9-89	7)_ <i>[[</i>	1-16	7-18
Quality Control	***************************************							7	7	17		' /

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DQA:			Date:										TOAC
						WORK ORDER NON	-CC	ONFO	RMANCE / UPD	PATE			AEROSPACE
QA Closed:			Date:						·	V	Vork Order up	odate only	,
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
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Part N	JO.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•••	·				Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR N	lo.					Suspected Unapproved	1		<u> </u>	Composite	†	Supplier	
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Root					Desc	ription of work order update	1	Initial	Action	1	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descript	tion	Date	Verification	QC Inspector
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		Cracks	of Concer	ittic	┢	Broken/Damage/Defect	_	Hardwa	ıre	-	Part Incorred		Temperature/Cure
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	_	Crimp/Kink/Ripple/Wave			\vdash	Contamination		4 '	ions Incomplete/Unc	<u> </u>	Part Moved	-	Wrong Stock Pulled
	Cuffs Crushing					Countersink	\vdash	4	ned/off center	-	Positioned V	∟∟ Vrong	
	Heat Treat			40		Cut Too Short	-	Mislabe		-	Power Loss/		Other
	Inspection Strip in Tube			Tube		Drawing	\vdash	Misread		_	······································		•
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		Wave/Tw				Fit/Function		Out of 9	Sequence			-	

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Page 4

June-03-14 7:12:27 AM D3391-025 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Aft Tube Assembly *1* **Start Oty: 1.00 Start Date: Cust Item ID:** Required Date: 6/03/14 Rea'd Otv: 1.00 *1* **Customer:** Reference: Run Start Process Plan: **Tooling:** Date: **Approvals:** Date: Stop QC: __ Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Code Qty Qty Number Stamp **Run Hours** 180 0.00 Skidtubes *120* Skidtubes 0.00 4-Open Aft cap pilot hole to .208" as per Dwg D3391 Skidtubes 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig. *****Do Not Open To Finished Size**** #-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5-Open wearplate holes to 0.297" and c'bore as per dwg D3391 6 Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. Z-Deburr 8- Seribe batch # on fwd end



DQA:			Date:											TRACT
0 & 6 1 1	t No. Date Step Qty					WORK ORDER NON-	-CC	ONFO	RMANCE / UP		ork Order up	odata anly	\Box	AEROSPACE
QA Closed:			Date:							VV	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS		
	_					Rework			Skid-tube	Crosstube	1	Water Jet		Engineering
Part N	lo.					Scrap		`	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Stoi	e/Packaging		Other
NCR N	No					Suspected Unapproved			Large Fab	Composite]	Supplier		
Root					Desc	ription of work order update		Initial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verificatio	n	QC Inspector
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Work Ord June-03-14 7:1		20030		*120) 030*						Page
Item ID: Revision ID:	D3391-025			Accept	*N900	04010	าก*	Setup	Star	t *N	S1*
Item Name:	Aft Tube Ass	embly							Stop	*N	S2*
Start Date:	6/03/14	Start Qty: 1.00	*1*		Cust Item 1	ID:					
Required Date	: 6/03/14	Req'd Qty: 1.00	*1*		Customer:						
Reference:			•								
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:		Run	Start	~1 <i>V</i> 1	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Pla	-	pt Re Qt	eject ty	Reject Number	Insp. Stamp
190		QC5- Inspect part compl	eteness to step on W/O	0.00		DAS	\sim				
1 QO QC Quality Control		Мето		0.00		9-89 9-89	17		14	'=10·	16

200 Chemical Conversion Coat per QSI005 4.1 0.00 *200* HandFinish 0.00 Memo Hand Finishing

210 QC7-Inspect Chemical Conversion Coat 0.00 0.00 Memo **Quality Control**

Page 5

DQA:			Date:						_					
						WORK ORDER NON	-CC	ONFO	RMANCE / UP		lank Ordan un	data anlu - F	_	AEROSPACE
QA Closed:			Date:					-		V	/ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
Work Orac	•					Rework	ıl		Skid-tube	Crosstube		Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	_	Other
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	<u> </u>	Cracks	of concer	HITIC	-	Broken/Damage/Defect	┢	Hardwa	aro.	-	Part Incorred	F	_	emperature/Cure
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			iny mppie,	/ wave		Contamination		· '	tions Incomplete/U	· —	Part Moved	- F	-	Vrong Stock Pulled
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Work Orde June-03-14 7:1.		120030		*120	1030*						Page 6
Item ID: Revision ID:	D3391-02	25		Accept	*N9000	າ40	100)*	Setup St	art *\	IS1*
Item Name:	Aft Tube A	assembly							St	op * /	IS2*
Start Date: Required Date:	6/03/14 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID Customer:):					,,
Reference: Approvals:		Plan:	Date:	_ Tooling: _	Date]	Run St	ор	IR1*
	QC:		Date:	_ SPC (Y/N):	Date	e:				*/	IR2*
Sequence ID/ Work Center II 220 *>>>\tau\tau\tau\tau\tau\tau\tau\tau\tau\tau		A/R Magna exp. date: 12 cure time 12 2- Grind cross	using #9 drill	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* OC		QC5- Inspect part comple	eteness to step on W/O	0.00					14-6	D-26	PD

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Memo

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Quality Control

DQA:			Date:										•	TQAG [~]
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF				_	AEROSPACE
QA Closed:			Date:								ork Order up	date only	丄	
Work Orde	 .					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
WOIK OIG	=1.					Rework			Skid-tube	Crosstube	7	Water Jet	\neg	Engineering
Part i	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	1	Quality
	,					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite		Supplier		
Root	_				Desci	ription of work order update		nitial	Acti	on	Sign &		Т	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification		QC Inspector
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		Cracks			lacksquare	Broken/Damage/Defect		Hardwa		_	Part Incorred	F	_	emperature/Cure
		Crimp/Kir	nk/Ripple,	/Wave	<u> </u>	Burrs		i '	ion Incomplete/Un	·	Part Lost/Mi	ssing	_	Veld
		Cuffs			<u> </u>	Contamination		4	ions Incomplete/U	nclear	Part Moved	L		Vrong Stock Pulled
		Crushing	h h		igspace	Countersink		•	ned/off center	L	Positioned V		_	
		-			Cut Too Short	-	Mislabe		L	Power Loss/	Surge	<u>c</u>	Other	
		Inspection Strip in Tube Drawing				•	$\overline{}$	Misread						
	—	Marks/Chatter Drill Holes				Drill Holes	$\overline{}$	Off-set						
		Turning S	equence			Finish		1	Calibration		<u> </u>	******		
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

Work Ore		20030		*120) 0.30*						Page
Item ID: Revision ID: Item Name:	D3391-025 Aft Tube Ass	embly.		Accept	*N900	040	10) *	_	art *	JS1*
Start Date: Required Dat Reference:	6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:				. "	15ン^
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:		1		art *\	JR1*
	QC:		Date:	SPC (Y/N):	D	ate:			St	op */	IR2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. r Stamp
235		Pressure Wash per QSI0	05 4.3	0.00					1	$\wedge \wedge A$	1
235 HandFinish Hand Finishing		Memo AND REAL	ODINE AS PER PAR09-	0.00				\ <u>\</u> \ <u>\</u>	4_	_ <u> </u>	whe
240		White Gloss(Ref:4.3.5.1)	per QSI005 4.3-Alum	0.00					1		DAS
940 Powder Coating		Memo START TIM OVEN TEM FINISH TIM	e: 8.00 perature: <i>33</i> 0	0.00 ح				/	Ø/	12/-/1-1 ₀	2

Page 7

250

QC3- Inspect Part Finish

0.00

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Memo

0.00

Quality Control

DQA:			Date:			_							,	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF				_	AEROSPACE
QA Closed:			Date:							V	ork Order up	odate only	$oldsymbol{\perp}$	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	•					Rework			Skid-tube	Crosstube	7	Water Jet	٦	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	٦	Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Stor	re/Packaging		Other
NCR N	۱o. ِ					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desci	ription of work order update		nitial	Acti	ion	Sign &		Т	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification		QC Inspector
Design														
Doc/Data														
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Handling/Pre									<u>.</u> :					
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Transport														
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							FAI	OLI CA	regory		·			
Landii						General Bend	_	ادمانه را	rogram		Outside Dim	onsions F	٦,	Pressure/Forced
	_	Bending Centre No	nt Canaan	atria	-	BOM/Route		Grain	Togram	-	Over/Under	⊢		Set-up
		Cracks	of Concer	ILIIC	-	Broken/Damage/Defect	\vdash	Hardwa	uro.	-	Part Incorred	_	_	Temperature/Cure
•	-	Crimp/Kir	nk/Rinnle	/\ <i>M</i> >ve		Burrs			ion Incomplete/Un	gualified —	Part Lost/Mi	 	-	Weld
	-	Cuffs	Мирріс	, wave	-	Contamination		i i	ions Incomplete/U	· -	Part Moved	-	_	Wrong Stock Pulled
		Crushing				Countersink	_	4	ned/off center	-	Positioned W	∟ /rong		
	-	Heat Trea	at			Cut Too Short		Mislabe			Power Loss/S	_	\neg	Other
		Inspection		Tube		Drawing		Misread		_				
		Marks/Ch	•			Drill Holes	T	Off-set						
	_	Turning S				Finish		4	Calibration					
1	I	Wave/Tw				Fit/Function		Out of S	Sequence					

Work Orde June-03-14 7:12		20030		*120) 030*							Page 8	
Item ID: Revision ID: Item Name:	D3391-025 Aft Tube Ass			Accept	*N900	<u>04</u> 0	1100	ገ*	Setup	Start Stop	171	S1* S2*	
Start Date: Required Date: Reference:	6/03/14 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	D:				Q			
Approvals:	Process Pl	an:	Date:	Tooling:	D:	ate:]	Run	Start	*N	R1*	
	QC:		Date:	_ SPC (Y/N):	Da	ate:	4			Stop	*N	R2*	
Sequence ID/ Work Center II 260 *260* HandFinish Hand Finishing)		erts as per Dwg D3391	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	7
270 +070 +		A/R Sikafl Sikafle	Cap as per Dwg D3391 ex-241/-291 N 30 x expiry date:) <u>(</u>				1				Das	

Quality Control

0.00 Memo

38 9-89

NOV 1 4 2014

280

280 Packaging

Identify as per dwg & Stock Location: \(\(\subseteq \)

0.00 D412-742-043/B124111

Packaging

Memo

0.00

DQA:			. Date:						_					TQAG"
			D			WORK ORDER NON-	-CC	ONFO	RMANCE / UPE		(a.al. O.al.a			AEROSPACE
QA Closed:			Date:								ork Order up	date only	_1	· · · · · · · · · · · · · · · · · · ·
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
					_	Rework			Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	ヿ	Quality
	-					Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite lglic]	Supplier		
								<u> </u>			- 		_	
Root					Desci	ription of work order update		Initial	Actio		Sign &			
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	4	QC Inspector
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Doc/Data	_													
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Latiuii	_	Bending				Bend		lealia/s	Program	Г	Outside Dim	ensions [\neg	Pressure/Forced
		Centre No	nt Concen	tric		BOM/Route	\vdash	Grain	ТОБГАТТ		Over/Under	<u></u>		Set-up
		Cracks	or concen	iciic		Broken/Damage/Defect		Hardwa	are		Part Incorred			Temperature/Cure
	—	Crimp/Kir	nk/Rinnle	/Wave		Burrs		4	ion Incomplete/Unqu	ualified —	Part Lost/Mi		_	Weld
	-	Cuffs	,,	, wave	-	Contamination	-	4	tions Incomplete/Unc		Part Moved			Wrong Stock Pulled
	$\overline{}$	Crushing				Countersink	-	4	ned/off center		Positioned W	∟ ∕rong		
		Heat Trea	ıt			Cut Too Short	-	Mislabe	=	<u> </u>	Power Loss/S			Other
		Inspection		Tube		Drawing	-	Misrea		_	_	- L		
		Marks/Ch	•			Drill Holes		Off-set				····		
	—┥	Turning S				Finish		Out of	Calibration		**			
	\dashv	Wave/Tw		e		Fit/Function		Out of	Sequence					

Work Ord June-03-14 7:1		20030		*120) 0.30*							Page 9
Item ID: Revision ID: Item Name:	D3391-025			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	6/03/14 : 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	*N	R1* R <i>2</i> *
Sequence ID/ Work Center I 290 *>>ON* QC Quality Control	D	Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp

DQA:			Date:						_					
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF		(_	AEROSPACE
QA Closed:			Date:				_				ork Order up	date only		:- 1.
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	•					Rework	1		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	No.					Scrap		Ì	Machining	Small Fab	Pro	d. Eng. Coor.	ᆿ	Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	\exists	Other
NCR 1	No.					Suspected Unapproved			Large Fab	Composite] .	Supplier		
Root					Desc	ription of work order update		Initial	Acti		Sign &		-	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	4	QC Inspector
Design	Щ													
Doc/Data														
Equip/Tooling														
Handling/Pre							İ							
Material														
Operator														
Offset/Setup														
Process														
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Transport	Щ													
Unapproved			<u></u>				<u> </u>		50004					
							FAI	ULI CA	regory	· <u></u>				
Landi	$\overline{}$				Г	General		1:-/5			Outside Dim	: Г	\neg	Pressure/Forced
	-	Bending		ant i	-	Bend BOM/Boute	<u> </u>	1	rogram		Over/Under	-		Set-up
		Centre No	ot Concen	itric	<u> </u>	BOM/Route	\vdash	Grain		-	Part Incorred	-		Set-up Temperature/Cure
	-	Cracks	ala/Dimmla	/\4/=	\vdash	Broken/Damage/Defect	\vdash	Hardwa		evolition	Part Lost/Mi	-		Weld
	-	Crimp/Kir	тк/ктррге,	/ wave	-	Burrs	<u> </u>	4	ion Incomplete/Un ions Incomplete/U	· —	Part Moved	22111g	—	Wrong Stock Pulled
	-	Crushing			\vdash	Contamination Countersink		4	ned/off center		Positioned V	L Vrong		vvi ong stock Fulled
	-	Crushing Heat Trea	·+			Cut Too Short		Mislabe		-	Power Loss/			Other
		Inspection		Tubo	\vdash	Drawing	_	Misread		<u> </u>	Trower ross/	Juige [<u> </u>	Other
		Marks/Ch	-	iube		Drill Holes		Off-set						
	_	Turning S				Finish		4	Calibration				_	
	$\overline{}$	Wave/Tw		e		Fit/Function	_	4	Sequence		-		-	**** *********************************
1			.5	-		1,	ı	1						

Picklist Print

June-03-14 7:12:30 AM

Work Order ID: 120030

120030

Parent Item:

D3391-025

D3391-025

Parent Item Name:

Aft Tube Assembly

Start Date: 6/03/14

Required Date: 6/03/14

Page 1

2

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev B 06-02-07

ECN773 dwg rev. D EC

IPP Rev:C 06-03-28 Update Manuf. Instructions JLM

IPP rev D 07.03.20 revF dwg rev G dwg ecn 1053p EC verified by: DD

EC

IPP rev E 07.11.07 IPP Rev:F 07-11-13

ECN 1056

DD verified by: EC

IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H

11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047	, , , , , , , , , , , , , , , , , , , ,	Manufactured	No			260	Each	14.0000	1	1			
D4095-04 Wearpad Assembly	17								**	31205	23 (1x) Ill	14/11/1-
•				Location	<u>1</u>	Loc	<u>Oty</u>	Loc Code					
				FP001			14						
					102241		2		_				
					108289		12		_				
D4095-049		Manufactured	No			260	Each	9.0000	1	1			
D4095-04 Wearpad Assembly	19								**	1204	५५ (।	d Il	2 who
				Location	<u>l</u>	<u>Loc</u>	<u>Oty</u>	Loc Code					
				FP001			9						
					109670		9						
D6014-090		Manufactured	No			100	Each	63.0000	1	1			
D6014-09 ALUMINUM EXTRUSION	3O								**				
				Location	1	Loc	Qty	Loc Code					
				LG003			63						
					797 <u>4</u> 2		17						. /
					(86063)		46				Mm,	1-14	108/18

DQA:			Date:				_							
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		ork Order up	date only	П	AEROSPACE
			·. · · · · ·			DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS		
Work Orde	er: _										7			-
Part f	No					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	-	Water Jet d. Eng. Coor.		Engineering Quality
NCR I	No			···=-···		Use-as-is Suspected Unapproved		Therm	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	—	Other
Root					Desci	ription of work order update		nitial	Actio	on	Sign &	-		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verificatio	n	QC Inspector
Design								-			·			
Doc/Data	Ш													
Equip/Tooling	Ш								,					
Handling/Pre														
Material	Ш													
Operator	Ш													
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved	П						1							
							FAI	ULT CAT	TEGORY					
Landi	ng G	ear				General		_						•
		Bending				Bend		Folio/P	Program		Outside Dim	ensions	Ш'	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	ĽĬ;	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ાં -	╝	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unq	ualified	Part Lost/Mi	ssing	<u></u> Ш'	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/Un	ıclear	Part Moved		\ ا	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong		
		Heat Trea	ıt			Cut Too Short		Mislabe	eled		Power Loss/S	Surge		Other
	\square	nspection	n Strip in	Tube		Drawing		Misread	d					
	П	Marks/Ch	atter			Drill Holes		Off-set						
	<u> </u>	Turning S	equence			Finish		Out of (Calibration					
	\square'	Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Seauence					

June-03-14 7:12:30 AM

Work Order ID: 120030

120030

Parent Item:

D3391-025

Parent Item Name: Aft Tube Assembly

D3391-025

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

B119656lix Il whiz

D3670-4-200

Manufactured

Manufactured

230

Each

232.0000

Loc Code

**

D3670-4-200

Bushing

Location FG 87709 LG001 103880 109108 96240

62.0000

D2646

Aft Cap

Location Loc Qty Loc Code

FG 4 85848 2 2 90495 58 FP001 103306 3 107857 1 110816 13 31 113830 10 114495

DQA:		 .	Date:											`DART
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPD		ork Order up	date only	\Box	AEROSPACE
						DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Work Ord	er: .					B			Claid Audio C	Consiste of	7	\A/a+a= la+[Fu sin a suin s
Part I	۷o.					Rework Scrap Use-as-is			Skid-tube Machining noforming	Small Fab Finishing	-	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR I	No.			<u></u>		Suspected Unapproved		men	~ 	Composite	Rec/stor	Supplier	_	Other
Root					Desc	ription of work order update		nitial	Action	n	Sign &	· · · · · · · · · · · · · · · · · · ·	Т	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	n	QC Inspector
Design										-				
Doc/Data													l	
Equip/Tooling														
Handling/Pre														
Material			;										- 1	
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
							FAI	ULT CA	TEGORY					
Landi	ng (Gear	,			General		_			_			
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	'	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	!	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	i		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqu	ıalified	Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		Instruct	ions Incomplete/Unc	lear	Part Moved		'	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned W	rong _		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/S	Surge [\Box (Other
		Inspectio	n Strip in	Tube		Drawing		Misread	t					
		Marks/Ch	natter			Drill Holes		Óff-set						
		Turning S	equence			Finish		Out of 0	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print June-03-14 7:12:30 AM					P
Work Order ID: 120030		*120030*	Wyla III		
Parent Item: D3391-025		*D3391-025*			
Parent Item Name: Aft Tube Assembly				Start Date: 6/03/14 Start Qty: 1.00	Required Date: 6/03/14 Required Qty: 1.00
D3672-1	Manufactured	No	270 Each	1,238.000 2 2	
D3672-1 Phenolic Washer				**	liduliz
		Location	Loc Qty	Loc Code	
		FG	10	,	_
		85222	10	****	_
		Return2014	34		_

80369 34 ST060 1194 103845 4 112218 500 113581 500 93886 62 99099 128 14

ALS4-1032-130

AELS4-1032-130 Purchased

No

260 Each 7,504.000 14 **

Ill

AI S4-1032-130

Location	<u>on</u>	Loc Oty	Loc Code	
FP001		7399		-
	M128649	7399		_ X (4_
ST279		48		
	M128211	48		
st510		57		
	M126109	57		

Page 3

DQA:			Date:											
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		ork Order up	ndate only		AEROSPACE
QA Closed.			Date.			<u> </u>		l -		· · ·	 -			
Work Orde	er:					DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS		
	-					Rework			Skid-tube	Crosstube]	Water Jet		Engineering
Part N	۷o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Ш	Other
NCR I	Νο.					Suspected Unapproved			Large Fab	Composite	_	Supplier	Ш	
			1		0			(')	A	·	C: 0		$\overline{}$	
Root		Doto	Stan	Otic	Desc	ription of work order update or non-conformance		Initial		tion	Sign & Date	Verificatio	_	QC Inspector
Cause	\dashv	Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	ription	Date	vernication	╧	QC inspector
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Doc/Data														
Equip/Tooling Handling/Pre														
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Offset/Setup														
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Supplier														
Training														
Transport														
Unapproved	П											li.		
							FA	ULT CAT	EGORY					
Landi	ng G	Gear				General		_			_			
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	F	Pressure/Forced
	Ш	Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	tolerance	-	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ાં		Temperature/Cure
	Ш	Crimp/Kir	nk/Ripple	/Wave		Burrs		4 '	on Incomplete/Ur	•	Part Lost/Mi	ssing	_	Weld
	Ш	Cuffs				Contamination		4	ions Incomplete/l	Jnclear	Part Moved	Į.	\	Wrong Stock Pulled
	\vdash	Crushing			_	Countersink		•	ned/off center		Positioned V	- r		
	-	Heat Trea			<u> </u>	Cut Too Short		Mislabe			Power Loss/	Surge	(Other
	\vdash	Inspection		Tube	<u> </u>	Drawing	<u> </u>	Misread	I					
	Н	Marks/Ch			<u> </u>	Drill Holes	_	Off-set						
	-	Turning S			<u> </u>	Finish		4	Calibration					
	l l	Wave/Tw	ist in Tub	e		Fit/Function	l	Out of S	Sequence					

June-03-14 7:12:30 AM

Work Order ID: 120030

D3391-025

Parent Item Name: Aft Tube Assembly

120030 *D3391-025*

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

**

Required Qty: 1.00

ALS4-1032-225

Parent Item:

AELS8-1032-225 Purchased

270

Each

727.0000

AI S4-1032-225

* ALS7-1032-225

Location	<u>n</u>	Loc Oty	Loc Code	
FG		30		
	M127028	30	M136565	X &
FP001		423		
	M128649	423		
ST280		248		
	M127028	10		
	M128179	238		
st555		26		
	M127092	26	•	-

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:	_		Date:				_				ork Order up	date only		·
Work Orde	ır:					DISPOSITION				AGAINST D	EPARTMENT	PROCESS		
Work or ac	•				_	Rework			Skid-tube	Crosstube		Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	\neg	Quality
	•	•				Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	NCR No.				Suspected Unapproved			Large Fab	Composite		Supplier			
Root					Desci	ription of work order update	ı	Initial	Actio	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	1	QC Inspector
Design														
Doc/Data														
Equip/Tooling	_													
Handling/Pre														
Material														
Operator	_													
Offset/Setup														
Process														
Supplier													- 1	
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Transport														
Unapproved								UTCAT	FECODY					
112-						· · · · · · · · · · · · · · · · · · ·	FAI	ULI CA	regory					
Landir						General Bend		leolio/B	Program		Outside Dim	onsions [Pressure/Forced
		Bending Centre No	st Concon	tric		BOM/Route	-	Grain	Togram	 	Over/Under		-	Set-up
		Cracks	Concen	ittic		Broken/Damage/Defect		Hardwa	ıre	-	Part Incorred	ŀ	-	Temperature/Cure
	$\overline{}$		k/Rinnle	/Mave		1		1	ion Incomplete/Unc	rualified	Part Lost/Mi		$\overline{}$	Weld
		Cuffs	ik/ Mippic/	/Ripple/Wave Burrs Contamination				1 '	tions Incomplete/Ur		Part Moved	331116		Wrong Stock Pulled
		Crushing		Countersink				4	ned/off center		Positioned W	l /rong		with a state of the state of th
	_	Heat Treat Cut Too Short					_	Mislabe	· -	<u> </u>	Power Loss/S	- r		Other
	Inspection Strip in Tube Drawing							Misread		L		. U- [<u>-</u> -
	Marks/Chatter Drill Holes					=	H	Off-set						
	Turning Sequence Finish						Out of Calibration							
		Wave/Twist in Tube Fit/Function						ł	Sequence					

Picklist Print June-03-14 7:12:30 AM									Page 5
Work Order ID: 120030	101.	*1	20030*						
Parent Item: D3391-025			3391-025*	•					
Parent Item Name: Aft Tube Assembl	v	"1)	.a.a.g 1-0/:a	•	Sta	rt Date: (6/03/14	Rea	uired Date: 6/03/14
	,					art Qty:			quired Qty: 1.00
11/2011		N		270				Nec	funca Qty. 1.00
AN3C4A	Purchased	No		270 Ea	ach 2,750.000	6	6	000	1 1
AN3C4A						**			W(1112
			Location	Loc Oty	Loc Code				
			FG	20		,			
			122814	20	11/13671	(Ce			
			Return2014	9					
			124221	9					
			ST350	13					
			125388 M128606	3 6			-	_	
			M128739	4					
			ST350/513	26					
			M128606	26				_	
			ST512	3					
			124221	3					
			ST513	2679					
			M127410	1					
			M127832	62					
			M128634 M128879	616 2000					
AN3C5A	Purchased	No	W1120079	270 Ea	ch 991.0000	4	4		
	Turchased	110		270		**	7	. 1 1	1 1
AN3C5A					•	^^		<u> </u>	while
			Location	Loc Oty	Loc Code				
			FG	5	11(303	78			
			122800	5	1111202	3 0	X7		
			ST350	386					
			M128973	186					
			M129198	200				_	
			ST513 M128911	600 600					
			171120711	000					

DQA:	-		Date:			_							
						WORK ORDER NON-	-CO	ONFO	RMANCE / UI	PDATE			AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	<u></u>
NA onle Onde						DISPOSITION							
Work Orde	-					Rework		Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	مام					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raiti	٠٠					Use-as-is			noforming	Finishing	-	e/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite	-	Supplier	
,,,,,,	-	······································					ı				_		
Root					Desc	ription of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved													
							FA	ULT CAT	TEGORY				
Landi	ng G	ear				General		_			_	_	_
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ıtric		BOM/Route		Grain			Over/Under	tolerance	Set-up
:		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	: ધ	Temperature/Cure
		Crimp/Kir	k/Ripple,	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/L	Jnclear	Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong	
		Heat Trea	it			Cut Too Short		Mislabe	led		Power Loss/S	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misreac	I				
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of C	Calibration				
	Wave/Twist in Tube			e		Fit/Function		Out of S	Sequence				

June-03-14 7:12:30 AM

Work Order ID: 120030

D3391-025

Parent Item Name: Aft Tube Assembly

Parent Item:

120030 *D3391-025*

Start Date: 6/03/14

**

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

270

Each

5,404.000

10 10

NAS	11490	C0332R
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WASHER

Location	Loc Oty	Loc Code	
GA	825	1110077	<u> </u>
125654	825	11 (30325	<i></i>
Return2014	41		-
122063	41		
ST292	1380		
124580	8		
125654	8		
m128591	1364		
st510	3158		
m126319	61		
m127306	2500		
m127410	563		
m127831	34		

DQA:			Date:							e			
						WORK ORDER NON	-C(ONFO	RMANCE / UPD			–	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	r:					DISPOSITION			•	AGAINST DE	PARTMENT	/PROCESS	
WOLK OLGO	·· -					Rework	1		Skid-tube C	Crosstube		Engineering	
Part No	о.					Scrap			⊢	Small Fab	Pro	Water Jet d. Eng. Coor.	Quality
	_					Use-as-is		Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	o					Suspected Unapproved			Large Fab C	Composite]	Supplier	
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	QC Inspector
Design	_												
Doc/Data	_												
Equip/Tooling	4												
Handling/Pre	_												
Material	_												
Operator	\dashv												
Offset/Setup	\dashv												
Process	\dashv												
Supplier Training	-								İ				
Transport													
Unapproved	7					•	l.						
							FAI	ULT CA	TEGORY				
Landin	g G	ear				General		_			_		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	t Concen	tric		BOM/Route		Grain	P		Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	i _	Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/Unqu	alified	Part Lost/Mi	ssing	Weld
	Cuffs					Contamination	-	1	tions Incomplete/Uncl	lear	Part Moved	Ľ	Wrong Stock Pulled
	Crushing					Countersink	-	•	ned/off center	<u> </u>	Positioned V	_	¬ .
	Heat Treat					Cut Too Short	-	Mislabe			Power Loss/	Surge	Other
	Inspection Strip in Tube					Drawing	⊢	Misread					
	Marks/Chatter					Drill Holes	-	Off-set					
	_	Turning So			 	Finish	-	ł	Calibration				
1	- [Wave/Tw	ist in Tub	e		Fit/Function	<u></u>	Out of S	Sequence				

DART AEROSPACE LTD	Work Order:	120030
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 Rev: I		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		Lat	he Section	n	1.	
14.000	+/-0.010	14.000	V		tape	LG-11
3.500	+/-0.010	3.501	7		vers	CNC-08
Ø3.200	+/-0.010	3,202	_		1	
Ø3.750	+/-0.010	3-750	-			
30° x 0.060 chamfer	+/-0.010	30° × .060	1		J	
88.93	+/-0.030	88.920			tope	46-11

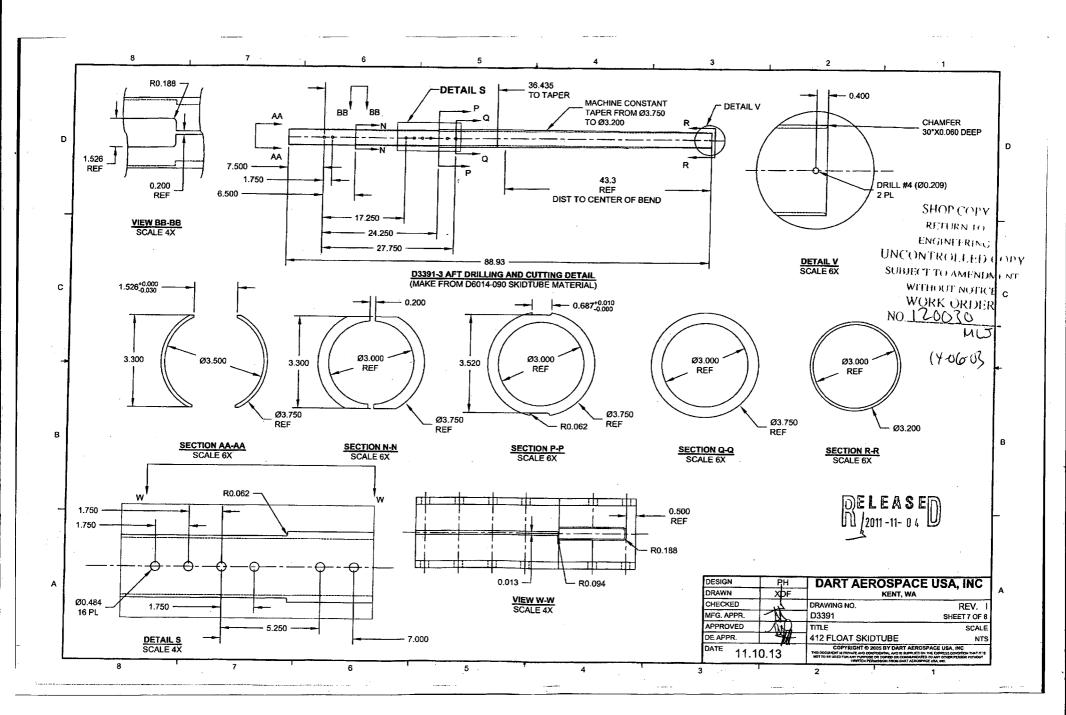
Measured by: | Mont | Date: |14/08/19 | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date: | Date:

		НА	AS Section
1.526	+0.000/-0.030	1-510	Vem
7.500	+/-0.010	7.504	./1
27.750	+/-0.010	27.250	n-tapl
31.750	+/-0.010	31755	16
35.250	+/-0.010	35.254	70.
3.300	+/-0.010	3.302	Vem
0.200	+/-0.010	.199	. 11
3.520	+/-0.010	3.526	11
0.687	+0.010/-0.000	,684	. //
R0.062	+/-0.010	.062	R-4
Ø0.484	+0.005/-0.001	-48ch	Vem

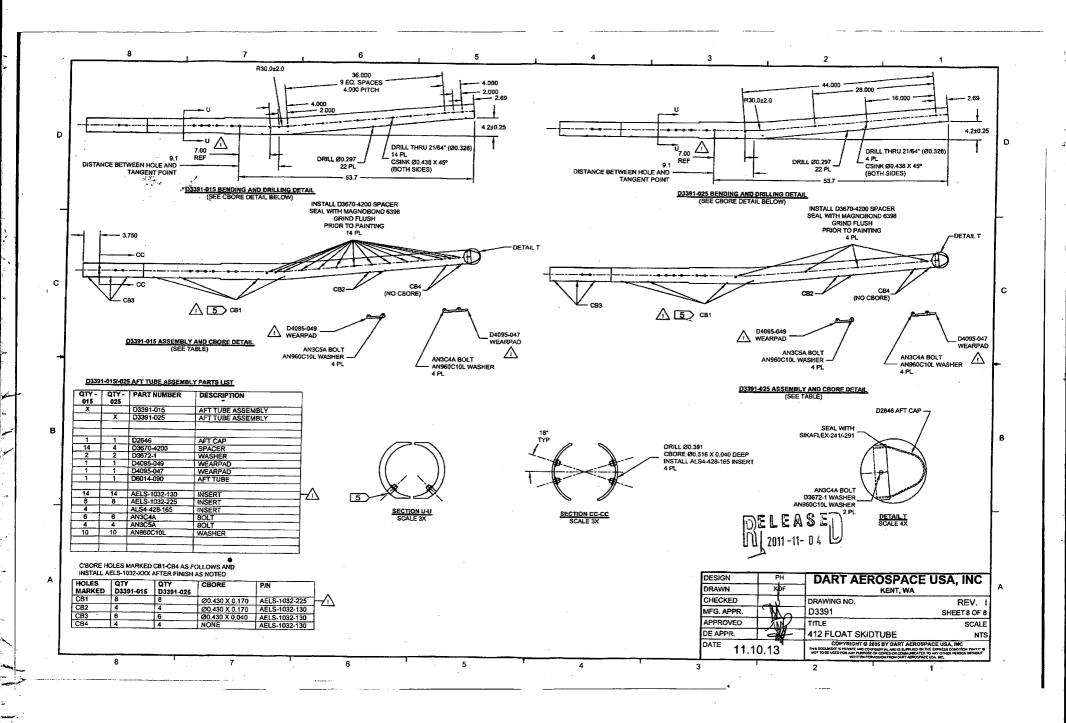
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Rev	Date	Change	Revised by	Approved
Α	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
В	06.06.19	Dwg revision update	KJ/JLM	
С	07.04.20	Ø0.208 dimension removed	KJ/JLM	·
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
. Н	11.06.21	Dimension 44.995 removed	KJ	
H N K	12.05.15	Dwg Rev updated	KJ	
£,,,,	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ 10	1.1
L	12:11.28	88.93 dimension added	KJ 😽	1.54

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			Work Order update only									AEROSPACE
Work Orde	·r·					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	Part No					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crossto Machining Small I Thermoforming Finish Large Fab Composi			b Prod. Eng. Coor. g Rec/Store/Packaging			Engineering Quality Other
Root					Desci	ription of work order update		nitial	A	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved							FAI	ULT CA	TEGORY						
Landir	ng G	ear				General									
		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea nspection Marks/Ch Furning So	k/Ripple t n Strip in atter equence	/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislabe Misread Off-set	ion Incomplete/Unions Incomplete, ined/off center eled	/Unclear		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	I۱	Wave/Tw	ist in Tub)e	1	Fit/Function	1	Out of 9	Sequence						



DQA:			Date:											
·,						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only								
QA Closed:			Date:							VV	ork Order up	date only		
Work Order:				DISPOSITION	-	AGAINST DEPARTMENT/PROCESS								
	-					Rework	1	Skid-tube	Crosstube	Water Jet		Engineering		
Part N	lo.					Scrap		l .	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is			noforming	Finishing	-{	e/Packaging	Other		
NCR N	lo.					Suspected Unapproved		Large Fab	Composite		Supplier			
						<u> </u>		<u> </u>			· · · · · · · · · · · · · · · · · · ·			
Root					Desc	ription of work order update	ı	Initial	Act		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector	
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Unapproved				<u>.</u>			<u> </u>				<u> </u>			
	FAULT CATEGORY													
Landin	ng G	iear	•			General	_	,		_	7		-	
		Bending				Bend		Folio/Program			Outside Dimensions		Pressure/Forced	
<u> </u>		Centre No	ot Concer	ntric	_	BOM/Route		Grain			Over/Under tolerance		Set-up	
<u> </u>	_	Cracks				Broken/Damage/Defect	<u> </u>	Hardware			Part Incorrect		Temperature/Cure	
	Crimp/Kink/Řípple/Wave					Burrs		Inspection Incomplete/Unqualified			Part Lost/Missing		Weld	
	_	Cuffs				Contamination		Instructions Incomplete/Unclear			Part Moved Wrong Stock Pu			
		Crushing				Countersink		Misaligned/off center			Positioned Wrong			
	_	Heat Trea	it			Cut Too Short		Mislabeled			Power Loss/	Surge	Other	
		Inspection	n Strip in	Tube		Drawing		Misread						
	Marks/Chatter					Drill Holes	Ŀ	Off-set						
	Turning Sequence					Finish	L	Out of Calibration					,	
	Wave/Twist in Tube					Fit/Function	1	Out of Sequence						



DQA:	Date:									TOART		
				WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:	13/2	Date:					,,,	1945 10 145	W	ork Order up	date only	
-Work Ord	er:	, co		;·	DISPOSITION		į		-3	PARTMENT		
Part I	No.	٤			Rework Scrap		• 1	Skid-tube Crosstul Machining Small F	_	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR No.					Use-as-is Tihermoformir Suspected Unapproved Large Fa			, , , , , , , , , , , , , , , , , , , ,	Finishing Rec/Store/Packaging Supplier			Other .
Root				Desc	ription of work order update	lı	nitial	Action		Sign &		and the second
Cause	Date	Step	Qty		or non-conformance	Chi	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling		, ,	17 m		y States							
Handling/Pre, Material Operator				of .				The Third The Th				*
Offset/Setup Process Supplier Training		100	t Seg									erionis de la companya de la compan
Transport Unapproved	.,	· ·					73.7		1)		· i	
			,			FĄL		regory		¥		
Landi	ng Gear	3	سرا		General		के प्रत्यक्षी <u>ती</u> संस्था		28	1	. (
**	Bending		* .		Bend			Program		Outside,Dim		Pressure/Forced +
*	Centre N	Not Concer	ntric		BOM/Route		Grain		•	1	tolerance	Set-up
	Cracks	سينه آنهيس		7	Broken/Damage/Defect	1	Hardwe			Part Incorred	· · · · · · · · · · · · · · · · · · ·	Temperature/Cure Weld
¥.	1	ink/Ripple	ywave		Burrs	-	-	ion Incomplete/Unqualified		Part Lost/Mi	ssing	
,	Cuffs			Contamination		Instructions Incomplete/Unclear Part Moved					Wrong Stock Pulled	
	Crushing Countersink Heat Treat Cut Too Short						Misaligned/off center Positioned Wrong Mislabeled Power Loss/Surge					Other
			T. J	^ -	Cut Too Short				٠ ــــ	Power Loss/:	surge	Other
		on Strip in	rupe		Drawing	-	Misread Off-set		**			·
	Marks/C			-	Drill Holes Finish	\vdash		Calibration				
		Sequence wist in Tub			Fit/Function	_		Sequence				